

Work Order ID 81060

March-07-12 2:26:07 PM

81060

Page 1

Item ID: D3189-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Chafing Shield

Start Date: 07/03/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

MLJ

Date:

12/03/07

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3189

Rev B

100

0.00

100

SHEAR

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: BProg Rev: B

2-Deburr if necessary

M 12.03.12 (20)

103

0.00

103

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

M 12.03.12 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81060

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March-07-12 2:26:07 PM

Item ID: D3189-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Chafing Shield
 Start Date: 07/03/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 21/03/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105 *105* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		5/26/12		count (x20)			
110 *110* Small Fab Small Fab	Small Fab Memo 1- Roll as per Dwg D3189 2- Apply a thin layer of Pro Seal on inside surface of chafing shield 0.03" - 0.06" thick as per DSI9549 and DEO D412-664-243.	0.00 0.00				(20) AS	FF	12-03-12	12-3-12 (20)
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5/26/14		count (x20)			

W/O:		WORK ORDER CHANGES					
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Work Order ID 81060***81060***


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Item ID: D3189-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Chafing Shield
Start Date: 07/03/2012 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 21/03/2012 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>L652</u>	0.00							
130									
Packaging	Memo	0.00				<u>AB</u>	<u>12-3-14</u>		
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/3/14 

12-03-14

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 81060

81060

Parent Item: D3189-1

D3189-1

Parent Item Name: Chafing Shield

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP B05.08.22No longer made in-houseKJ/JLM

IPP Rev:C 06-03-24 Rolling Now made in House JLM

IPP Rev:D 07-04-16 As per Rev B JLM

IPP Rev:E

11.05.11 now made on waterjet DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA		Purchased	No			100	sf	87.0000	0.32	6.736842			

M304S25GA

304/316 .020" Sheet

**

W 12 03 12

Location

Loc Qty

Loc Code

MAT020

87

117285

2

118228

85

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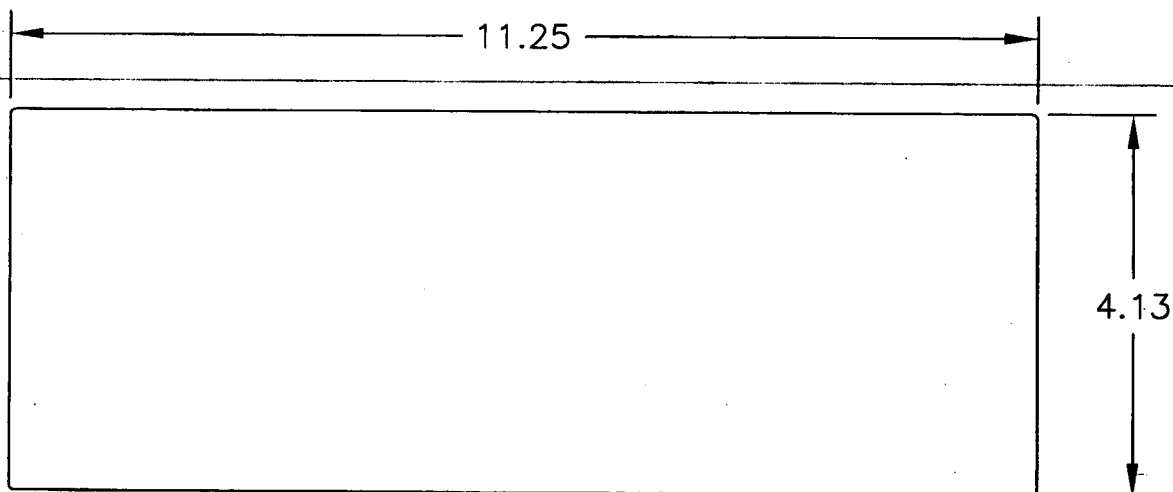
NOTE: Date & initial all entries

DART

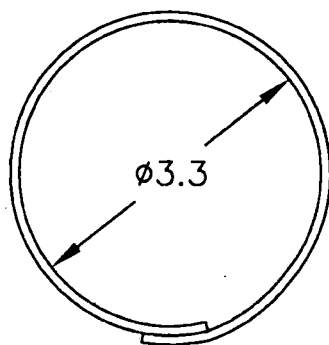
DESIGN QP	DRAWN BY QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3189	REV. B SHEET 1 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.08	NEW ISSUE	
B	07.01.05	ADD -3	

RELEASED

07.03.27 [Signature]



D3189-1 FLAT PATTERN

D3189-1 ROLLING DETAIL
NOT TO SCALE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81000
MCS (2/03) 07

D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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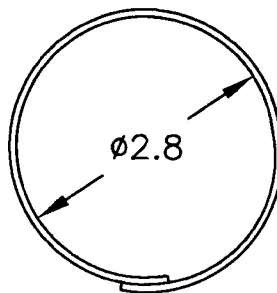
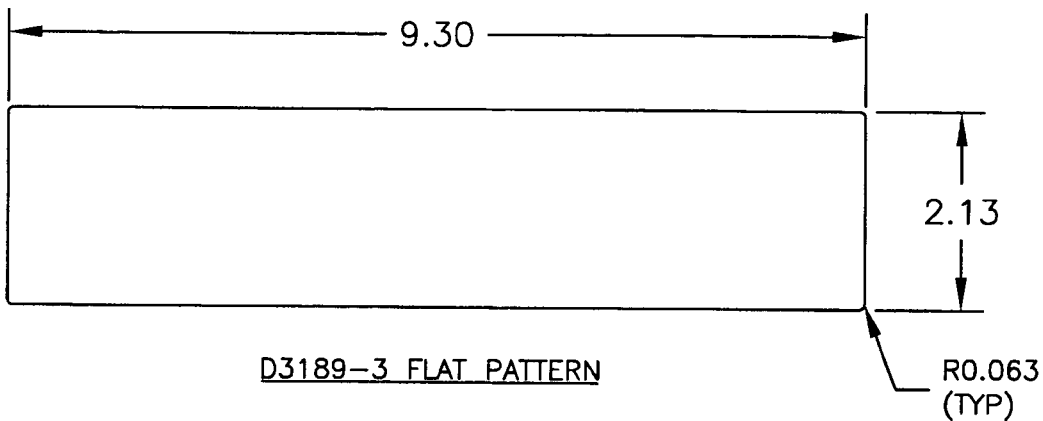
NOTE: Date & initial all entries

DART

DESIGN QP	DRAWN BY QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3189	REV. B SHEET 2 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2

RELEASED

07.03.27 [Signature]



D3189-3 ROLLING DETAIL
NOT TO SCALE

D3189-3 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
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- 5) ALL DIMENSIONS ARE IN INCHES

09018

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Dart Aerospace Ltd

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